












Date: Wednesday, 10/09/2008 3:40:54 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: GLARESHIELD ASSEMBLY
Job Number	: 41937	Part Number	: D3690041
Estimate Number	: 13291	Drawing Number	: D3690 REV B
P.O. Number	:	Project Number	:
This Issue	: 10/09/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : SMALL /MED FAB	Due Date	: 10/10/2008 Qty: 4 Um: Each
Previous Run	: 41207		
Written By	:		
Checked & Approved By	: <u>JUL 08.9.10</u>		
Comment	Est Rev:A 08-04-29 new issue DD verified by:ec Est Rev:B 08-07-14 revB as per dwg DD verified by:ec Est Rev:C 08-09-08 added painting DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
2.0	D36901	Glareshield	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Glareshield batch: <u>B41984</u> <u>JS 08/10/09</u> <u>(4)</u>			
3.0	D3697041	Tube Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Tube Assembly batch: <u>41985</u> <u>No at 15.</u> <u>JS 19/10/03</u> <u>(4)</u>			
4.0	D36981	Support Angle	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Support Angle batch: <u>41686</u> <u>JS 08/10/09</u> <u>(4)</u>			
5.0	AN960JD3	Washer	
			
Comment: Qty.: 6.0000 Each(s)/Unit Total: <del>24</del> 0000 Each(s) Washer batch: <u>M107989</u> <u>JS 08/10/09</u> <u>(4)</u>			



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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: GLARESHIELD ASSEMBLY

Job Number: 41937

Part Number: D3690041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20426AD34

RIVET



Comment: Qty.: 20000 Each(s)/Unit Total: 8.0000 Each(s)

RIVET

batch:

M105978

JS 08/10/09 (24)

7.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 35.0000 Each(s)/Unit Total: 440.0000 Each(s)

Rivet, Universal Head

batch:

1554

JS 08/10/09 (24)

PTO

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690

FF 09/01/13 (4)

2- scribe bath # and part # as per dwg

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/13 (24)

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: 1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg

2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.27

ml 09.01.15 (4)

11.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

S 09/01/15 (24)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location:

PP 41187 9/1/15 2x50

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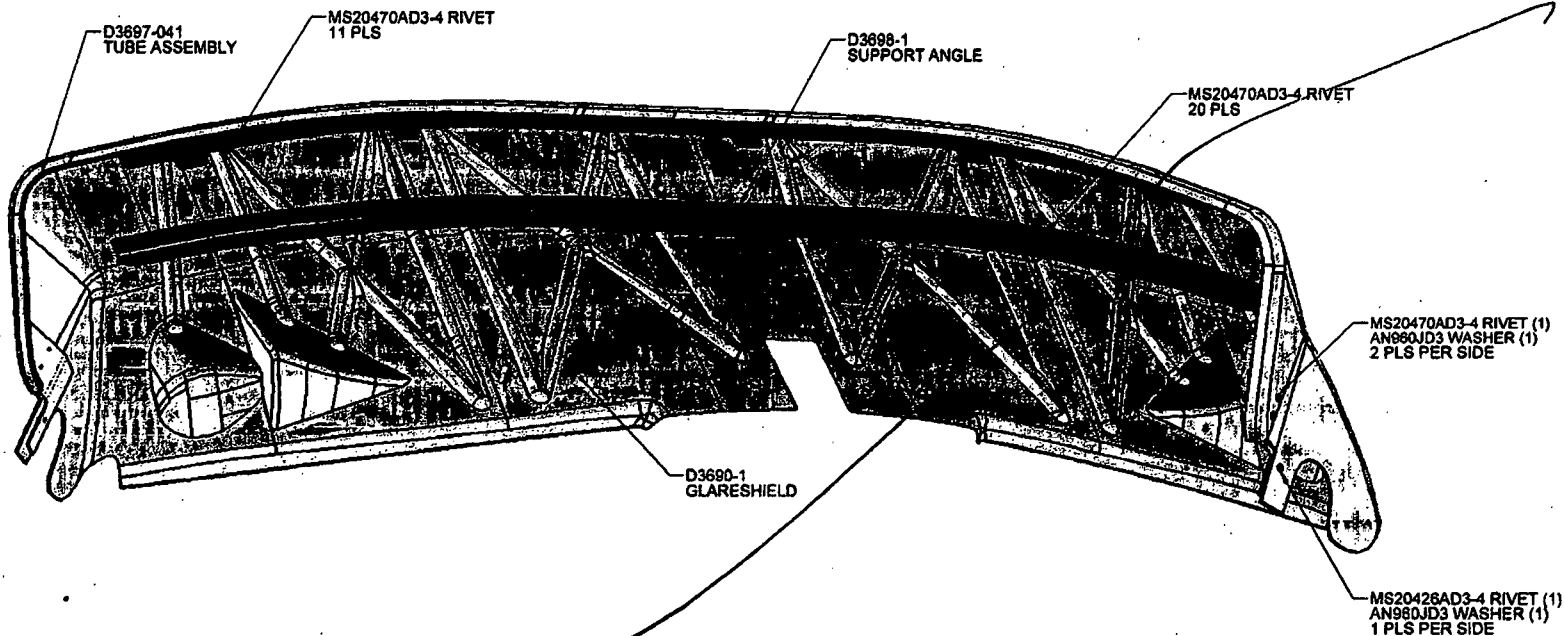
1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3690-041 PAR #: N/A Fault Category: Prod / Process / Material NCR: Yes No DQA: D Date: 09/01/16  
 Resolution: R-work Disposition: Rework QA: N/C Closed: D Date: 09/01/16

NCR: <u>41937</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/12	7	replace rivets MS20470AD3-4 qty 35 <del>MS20470AD3-4</del> for cherry rivet CR 3213-4-03 M14477	09/01/12	SUBSTITUTE RIVETS PER D3690 REV.C	FF 09/01/12	S 09/01/13	09/01/12	S 09/01/13
09/01/12	6	IF MS20426AD3-4 IS TOO SHORT, IT IS ACCEPTABLE TO REPLACE WITH A MS20426AD3-5 OR LONGER	09-01-12	ACCEPTABLE TO REPLACE WITH MS2046AD3-5 OR LONGER DASH NUMBER. M 4179 x 3	FF 09/01/13	S 09/01/13	09/01/12	S 09/01/13
09/01/13	8	hole for D3697-041 for Rivets one was drilled in wrong location. Through hole R.C. Hummon error / was not paying full attention	09/01/13	filled with Magnabond M109900 and sanded smooth.	09/01/13	S 09/01/13	09/01/13 PER ATTACHED	S 09/01/13

NOTE: Date & initial all entries



# PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
8	AN980JD3	WASHER (OR NAS1148DN332J)
2	MS20426AD3-4	RIVET
35	MS20470AD3-4	RIVET

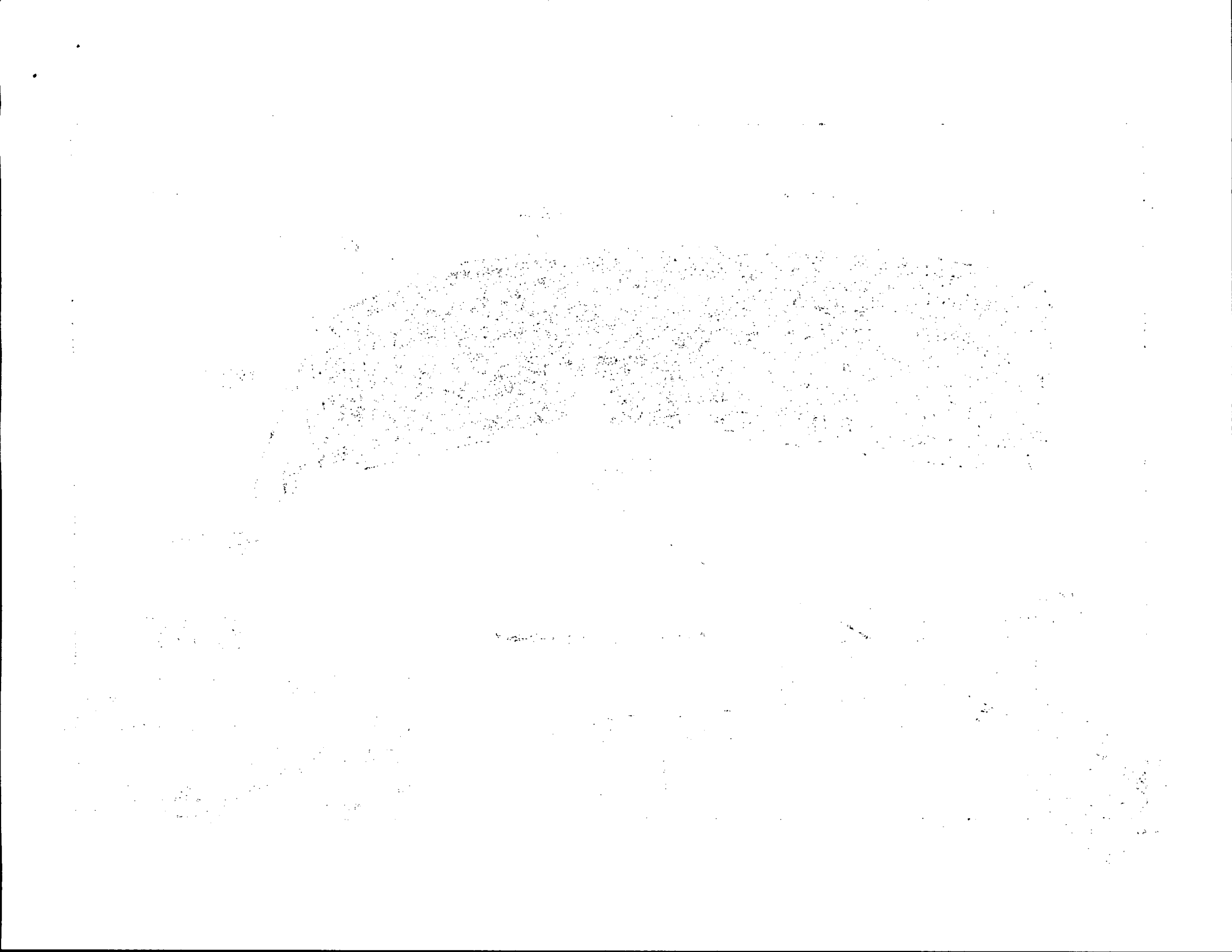
## D3690-041 GLARESHIELD ASSEMBLY

SEE REV. C  
09.01.12

RELEASED  
08.07.05

B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A,B & C,S; ADD MIN THICKNESS. SHEET 3 ZONE A,B	RF	08.06.24
A	NEW ISSUE	RF	06.05.20
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3690	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GLARESHIELD ASSEMBLY	NTS
DATE	08.06.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.	

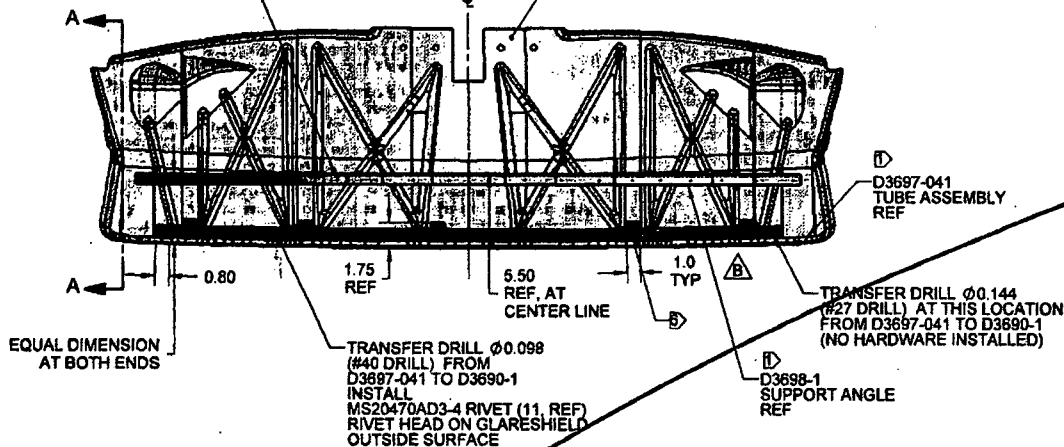
NO. 41157  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



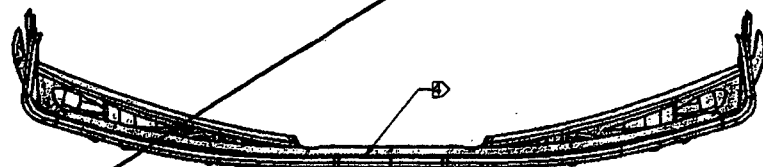
TRANSFER DRILL  $\phi 0.098$   
(#40 DRILL) FROM  
D3698-1 TO D3690-1  
INSTALL  
MS20470AD3-4 RIVET (20, REF)  
RIVET HEAD ON GLARESHIELD  
OUTSIDE SURFACE

D3690-1  
GLARESHIELD  
REF

TRANSFER DRILL  $\phi 0.098$   
(#40 DRILL) FROM  
D3697-041 TO D3690-1  
INSTALL  
MS20426AD3-4 RIVET (1, REF)  
AN960JD3 WASHER (1, ON GLARESHIELD  
OUTSIDE SURFACE)  
1 PER SIDE



# SECTION A-A



D3690-041 GLARESHIELD ASSEMBLY

DEE REV. C  
ATTACHED FOR  
MASKING/PAINT DETAIL

08-01-14

RELEASED  
08-01-14

## NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK MASKED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

NO. 11537  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. B
MFG. APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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